

**FIG. 1**

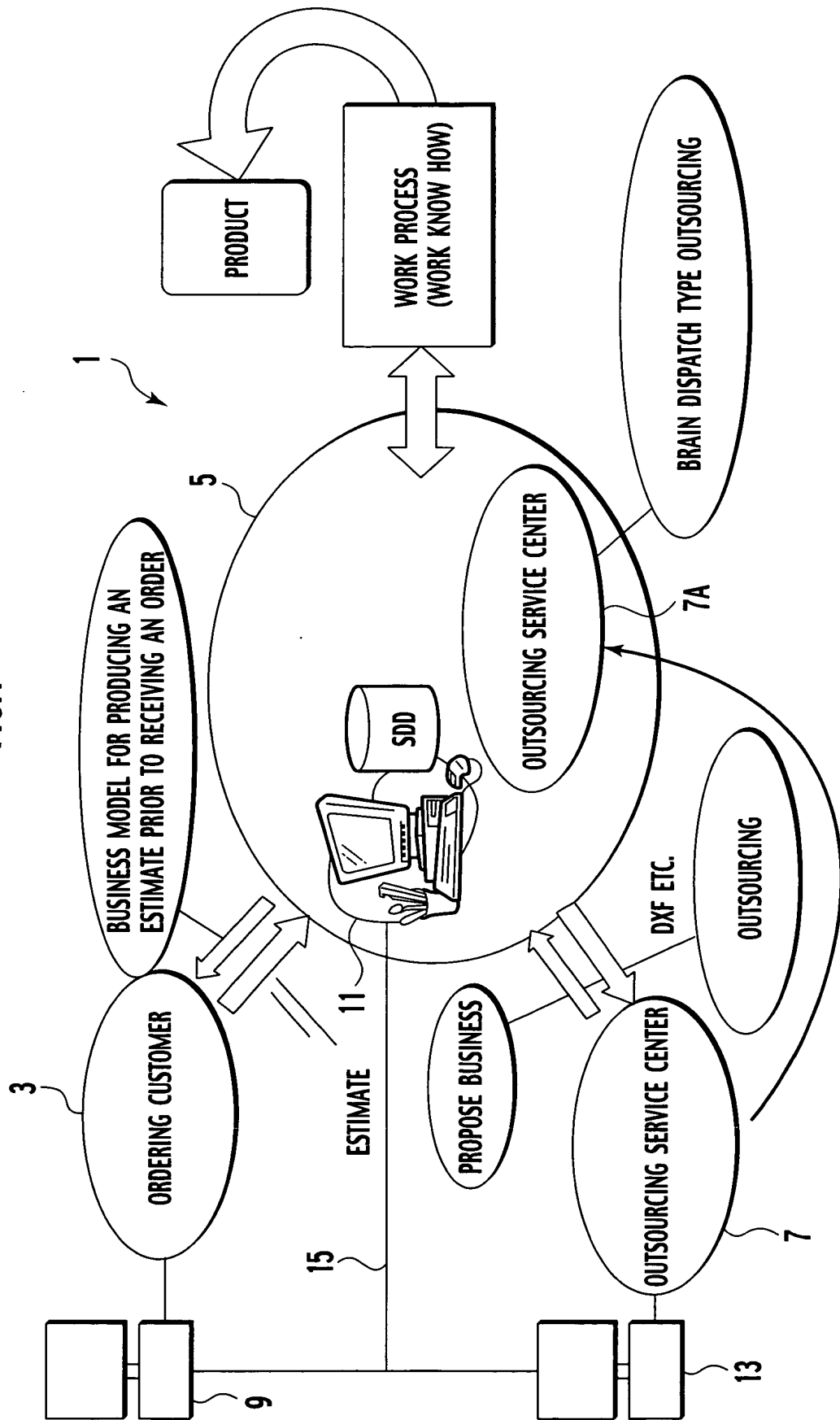


FIG.2

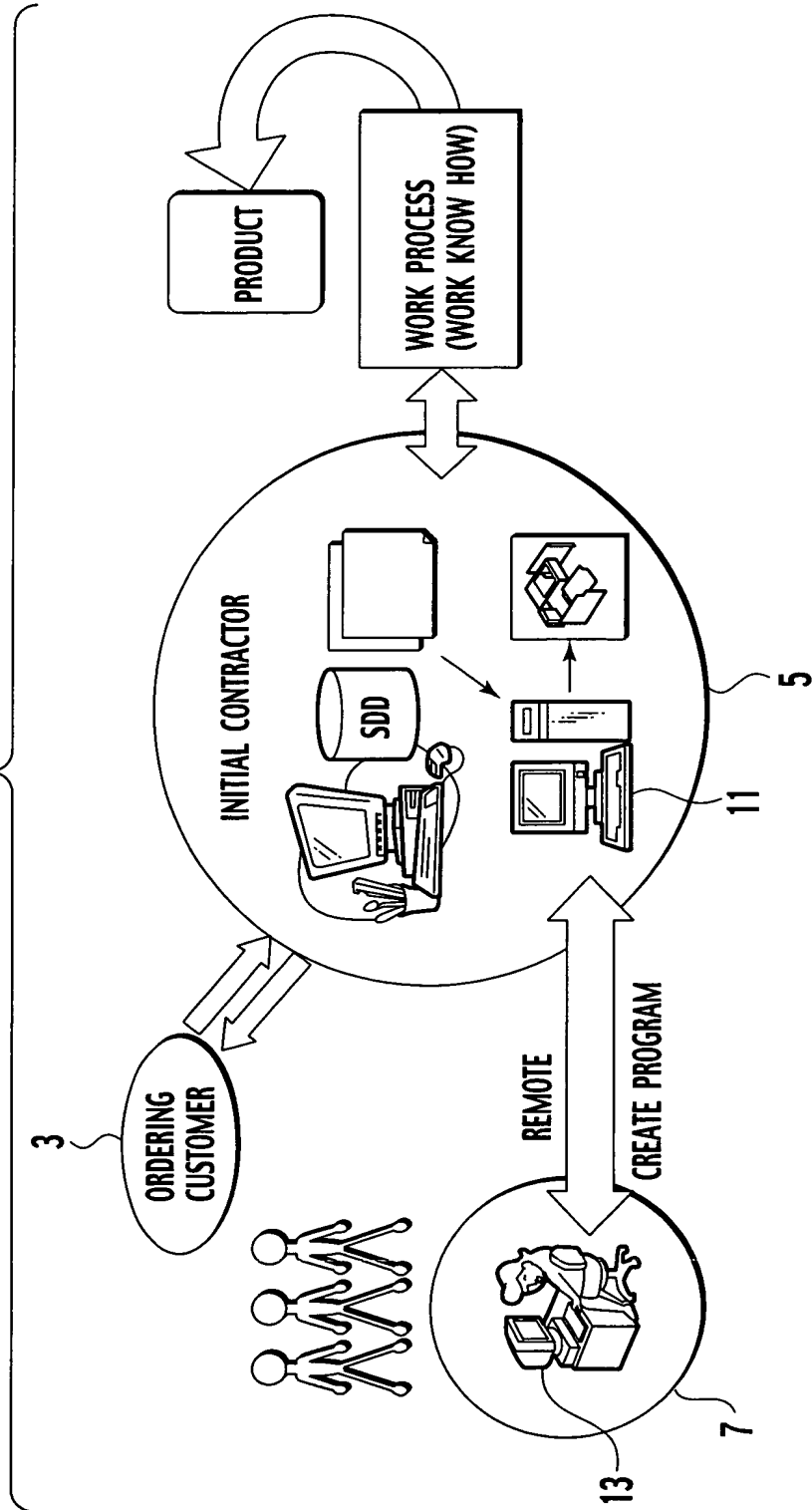


FIG.3

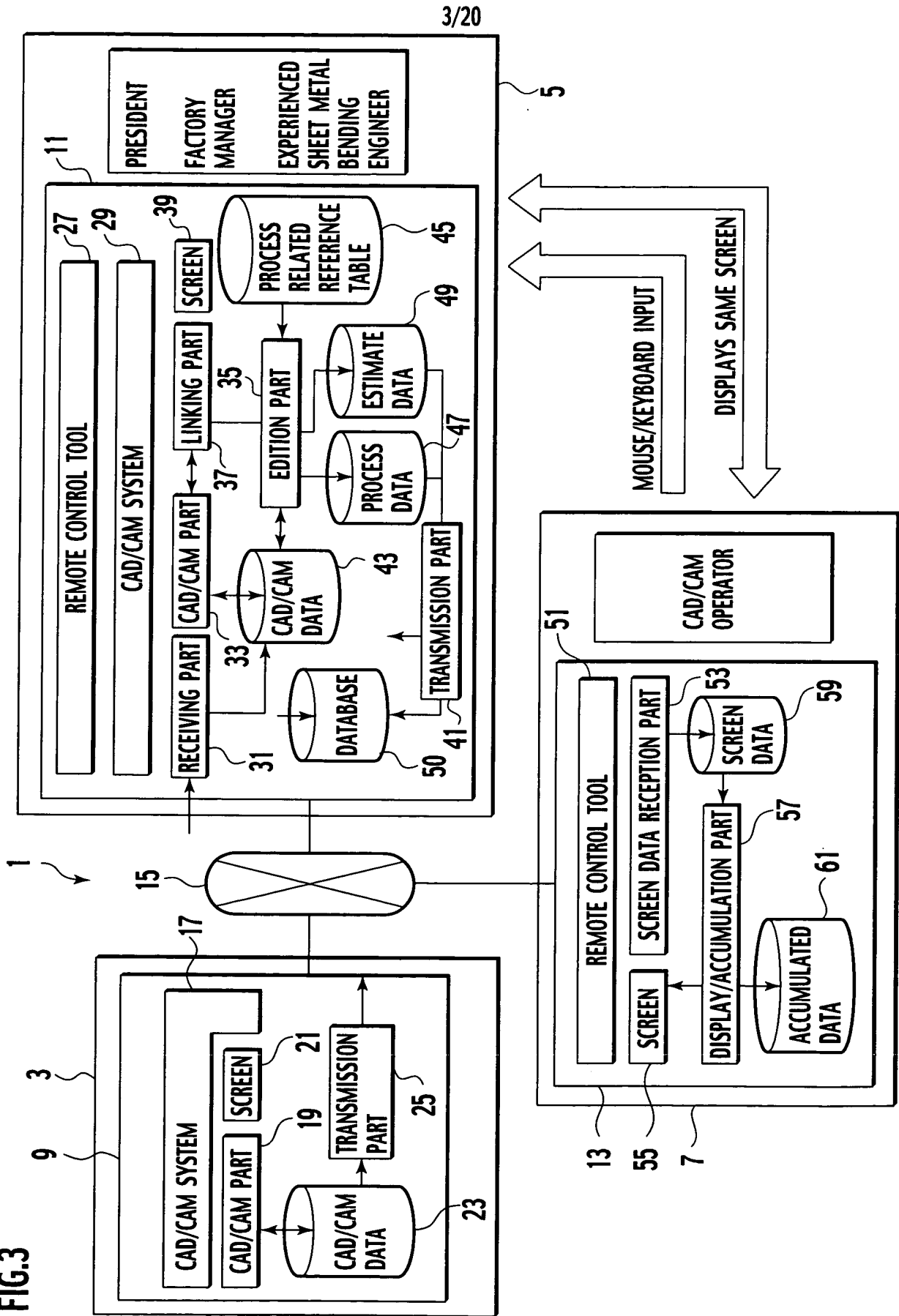
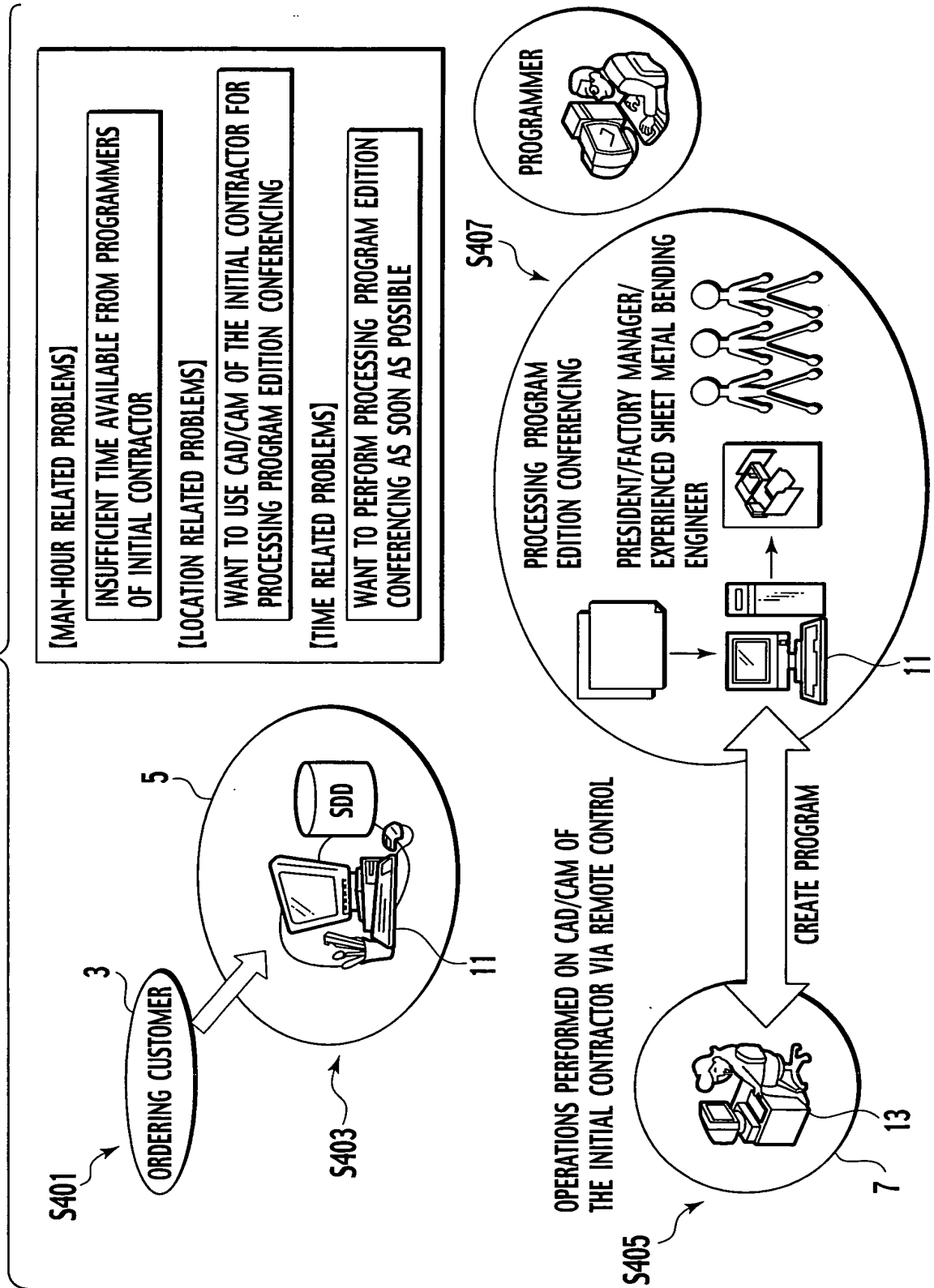


FIG.4



**FIG. 5**

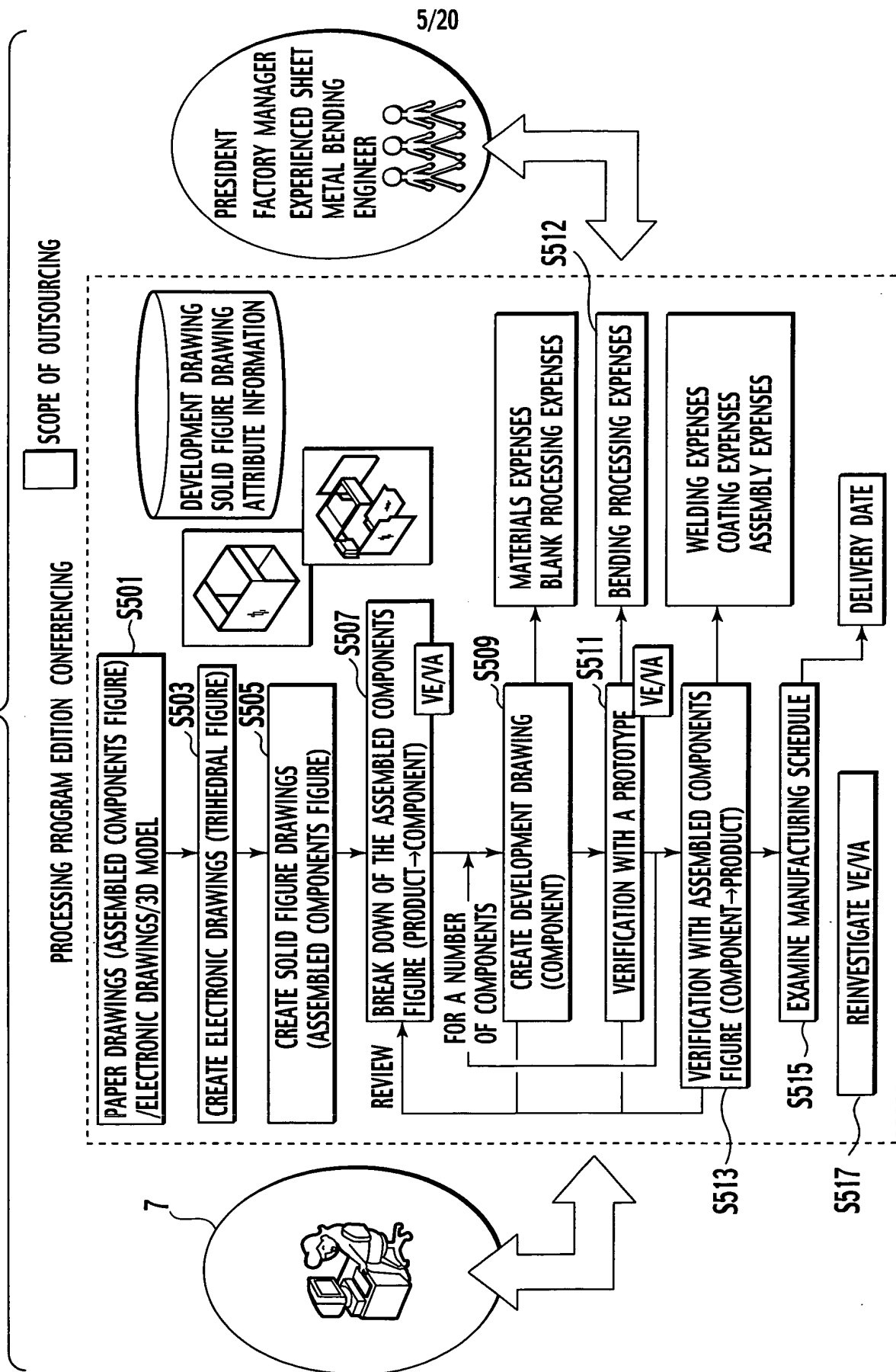


FIG.6

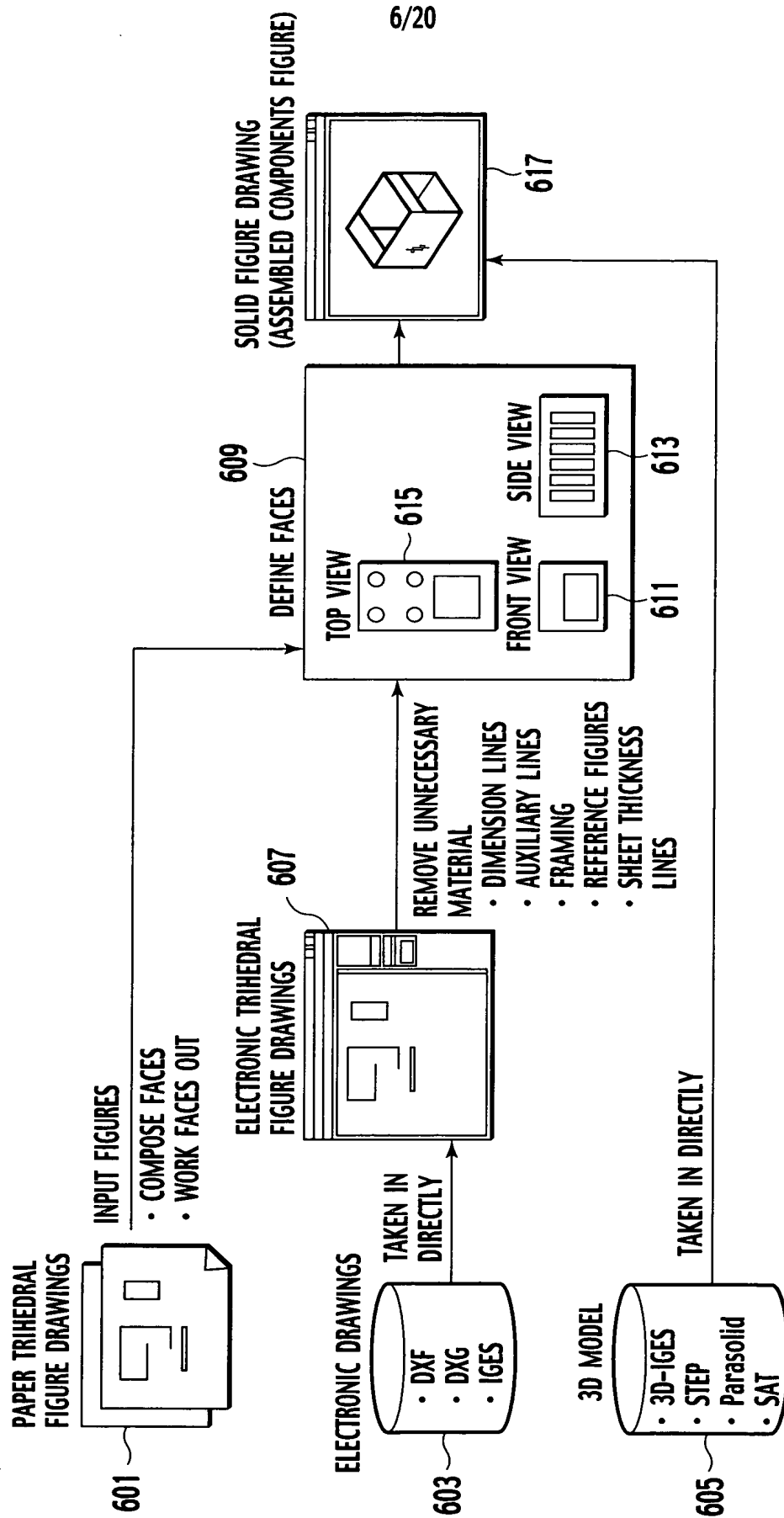


FIG.7

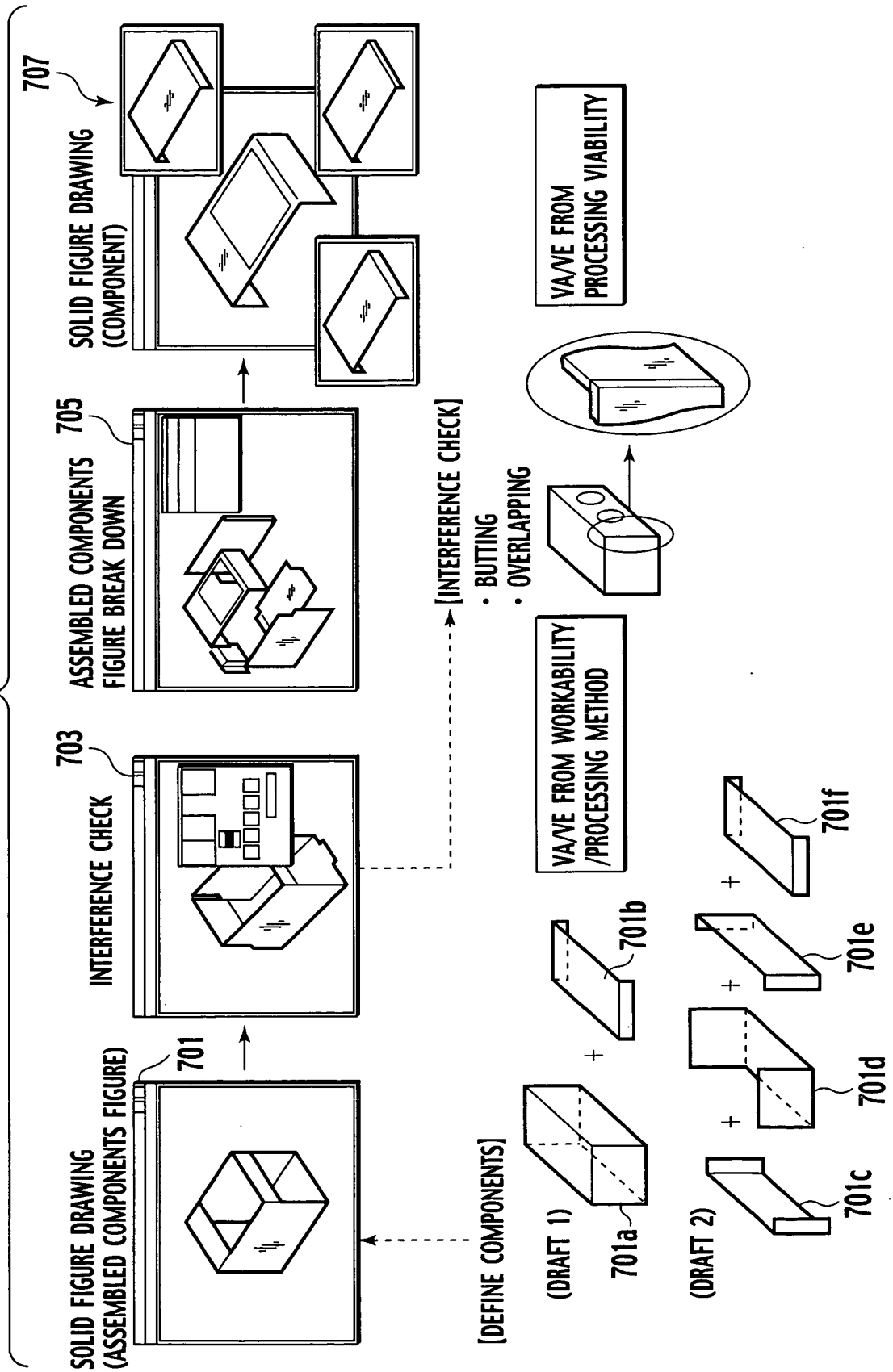


FIG.8

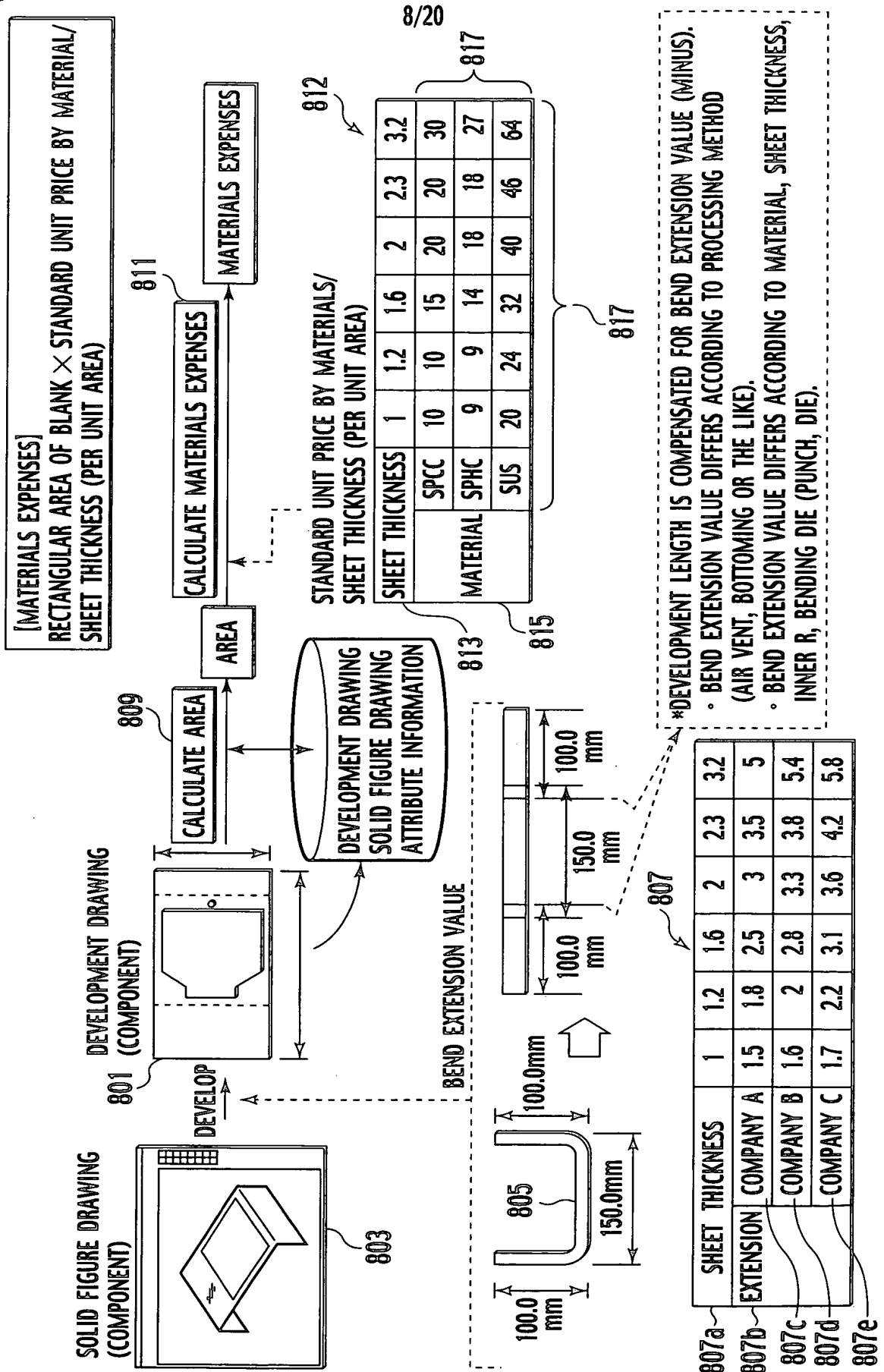




FIG.9

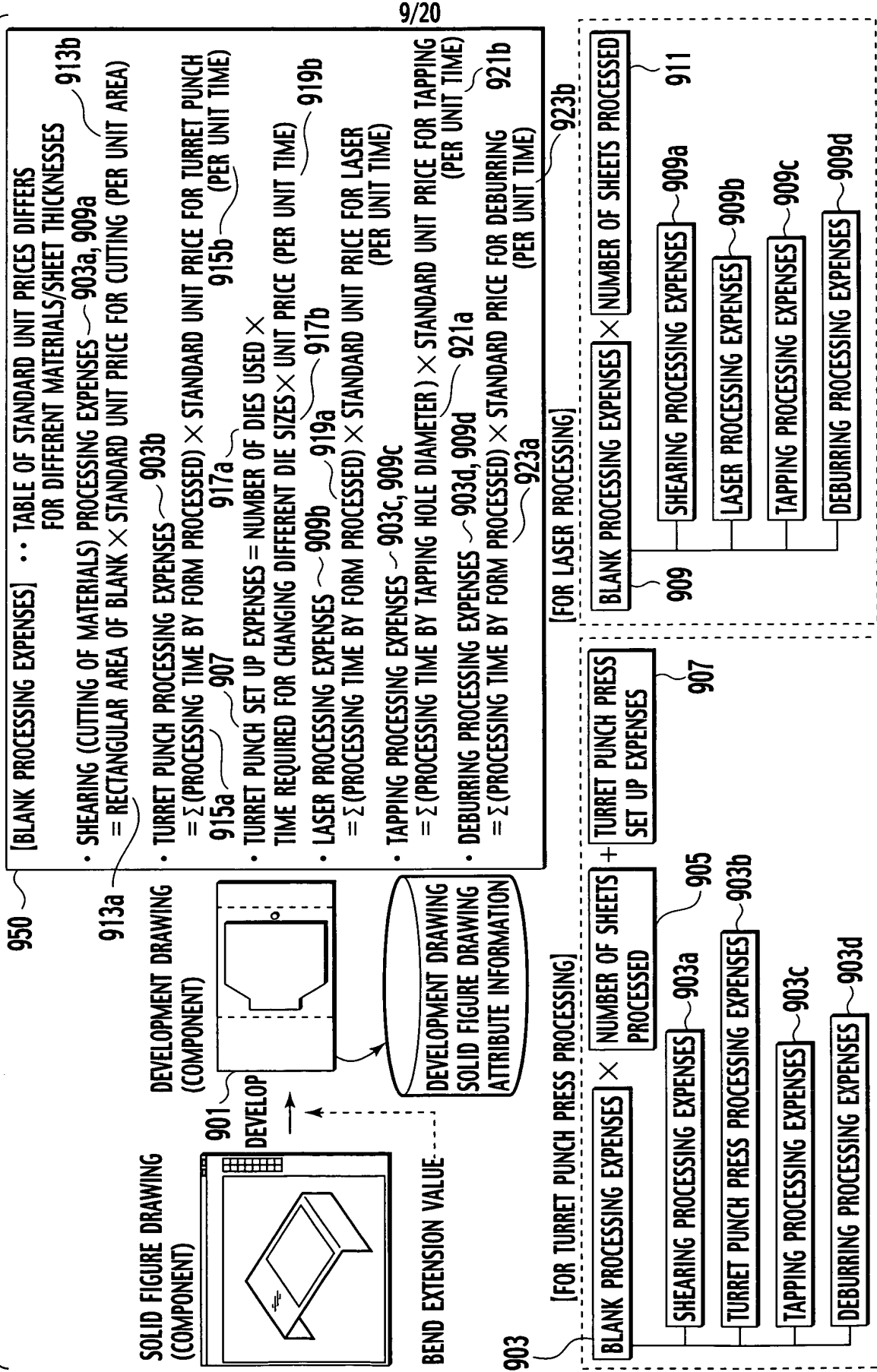
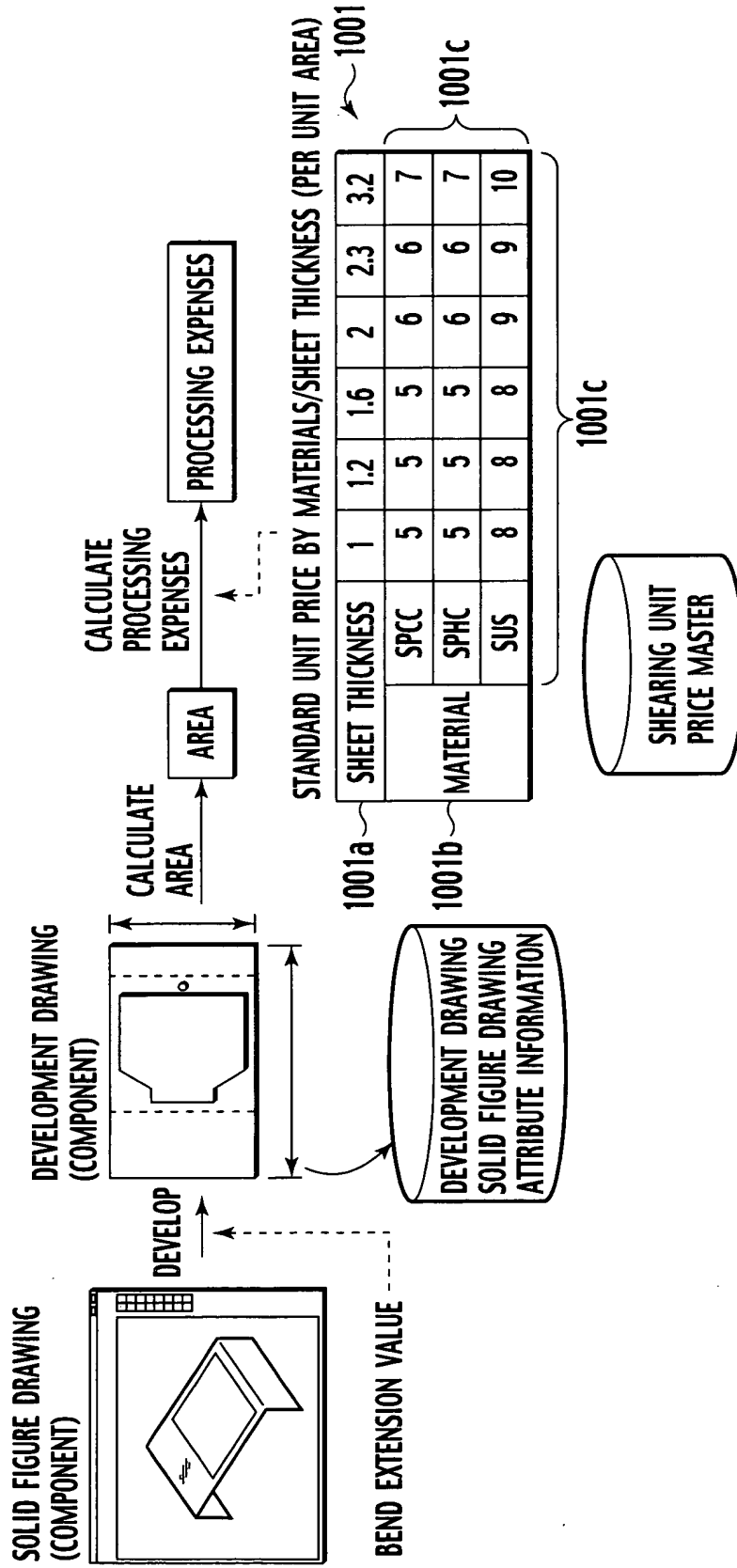
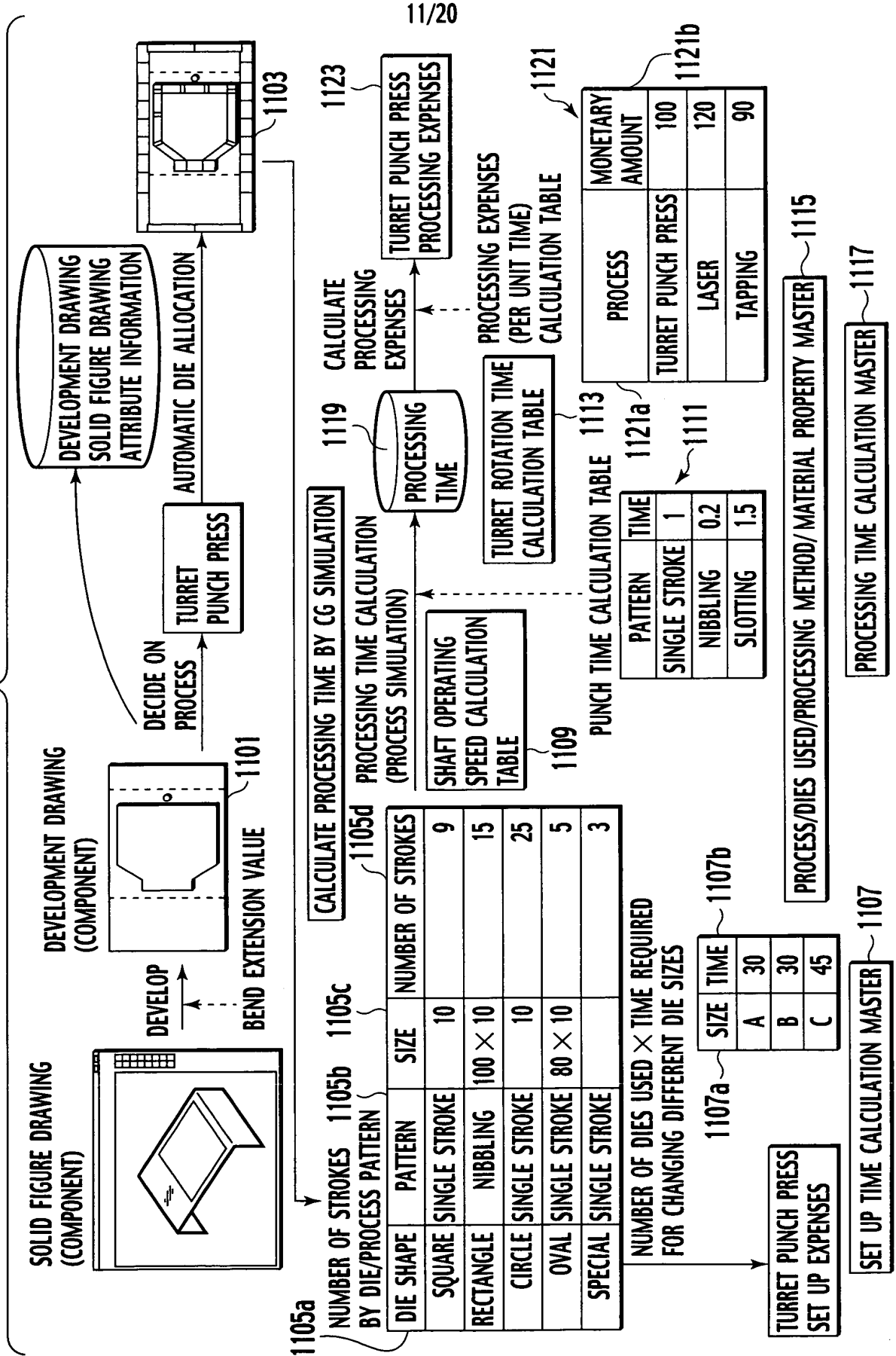


FIG.10



**FIG. 11**



**FIG. 12**

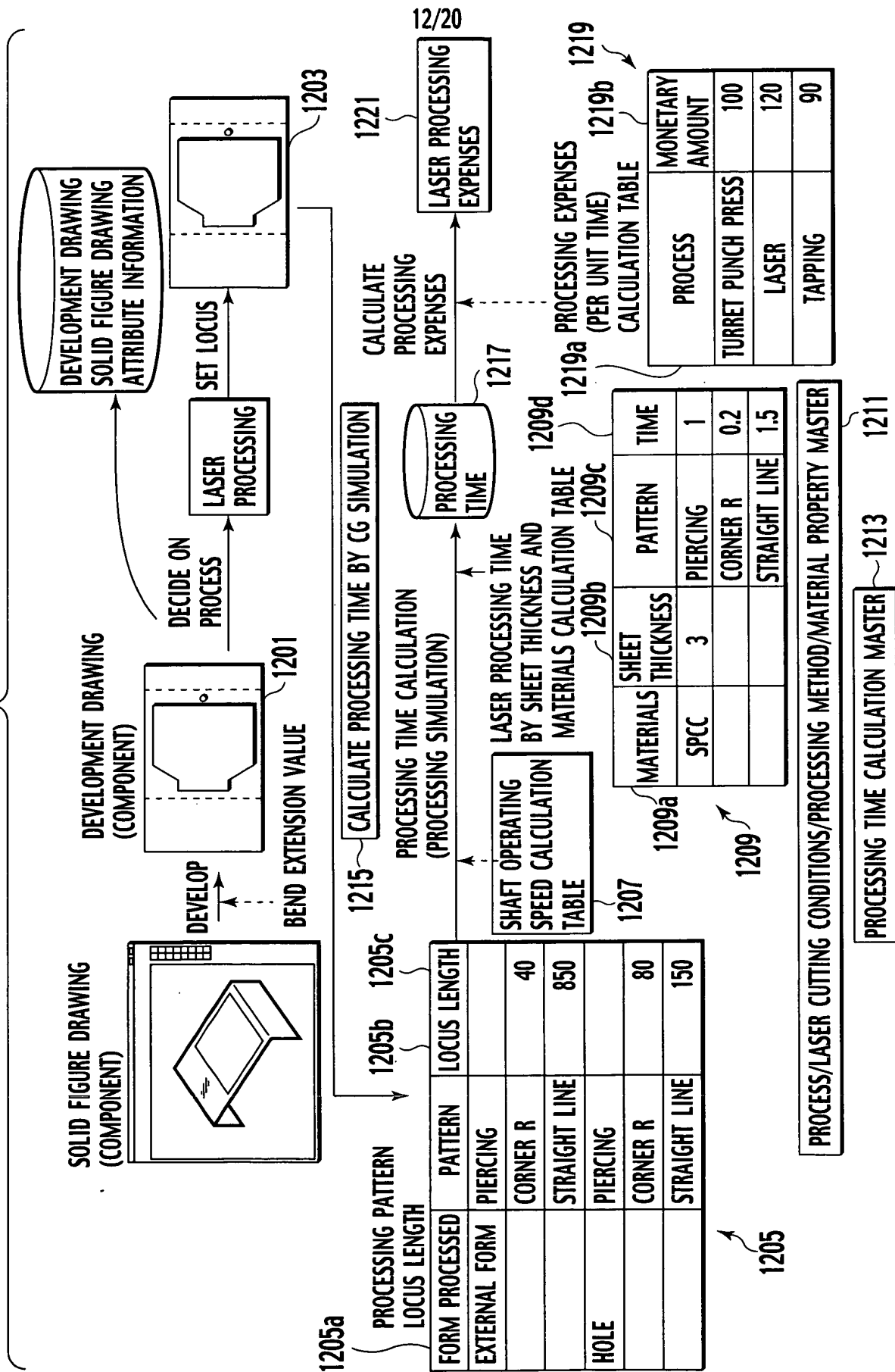


FIG.13

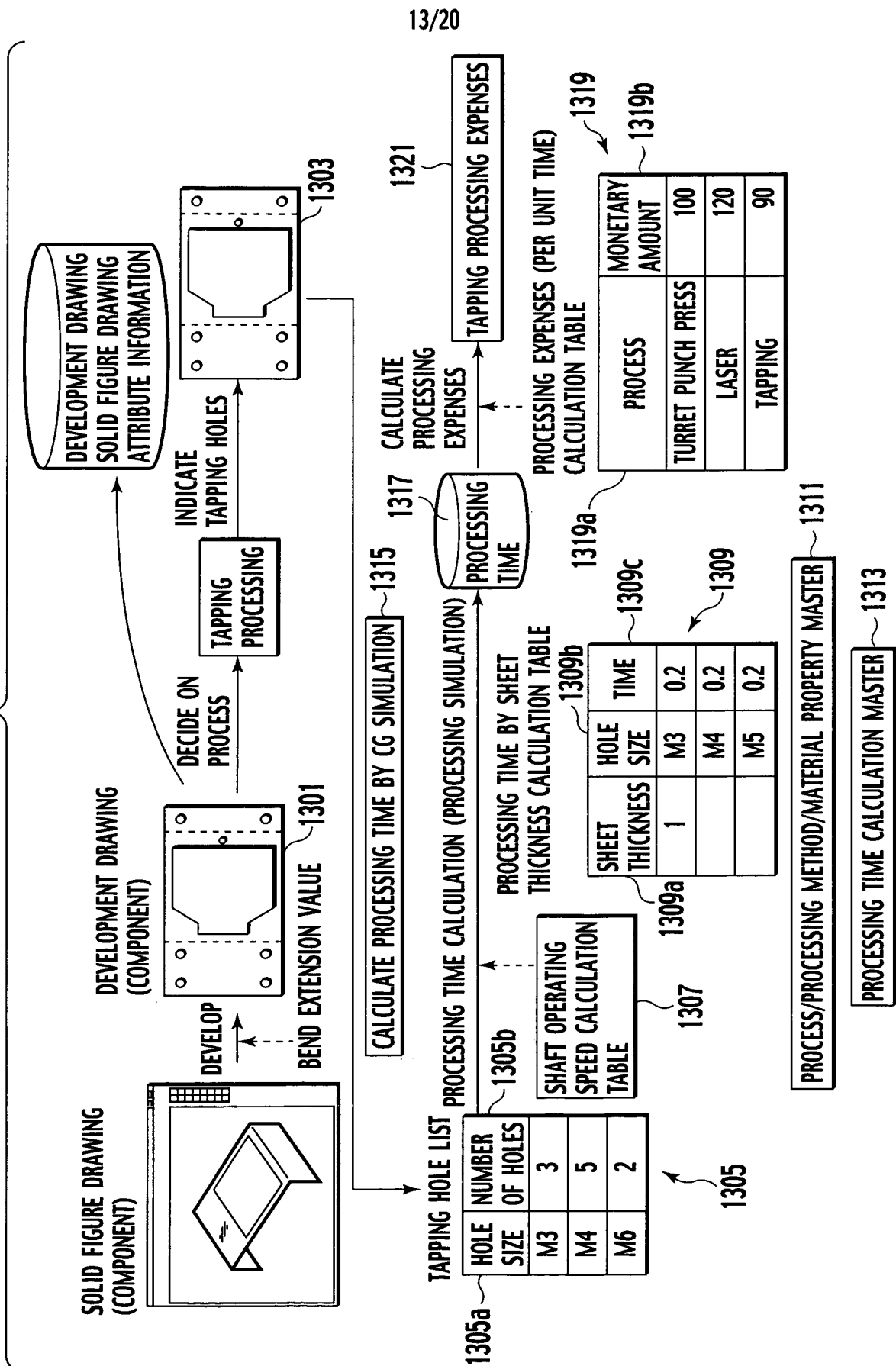
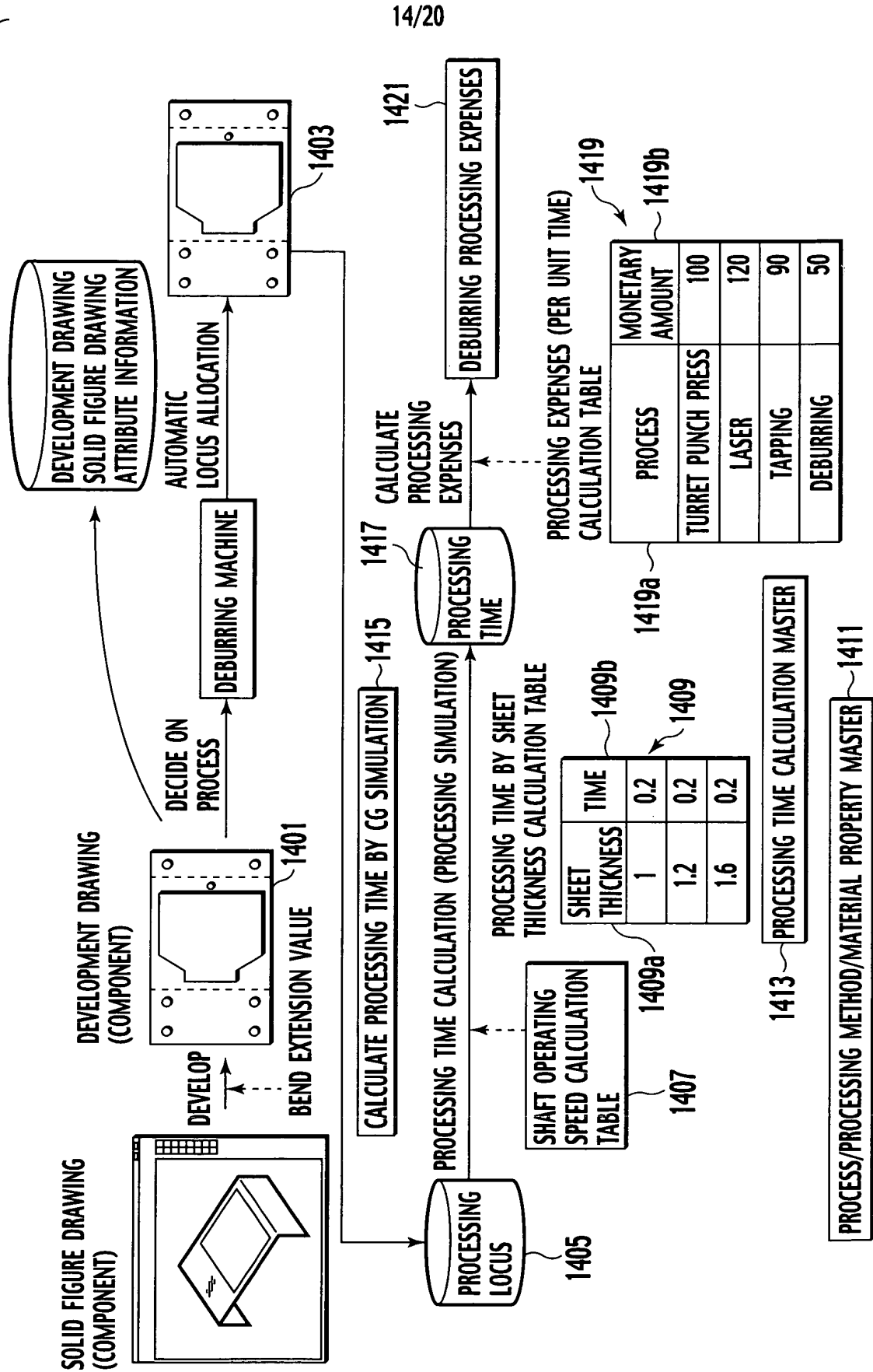
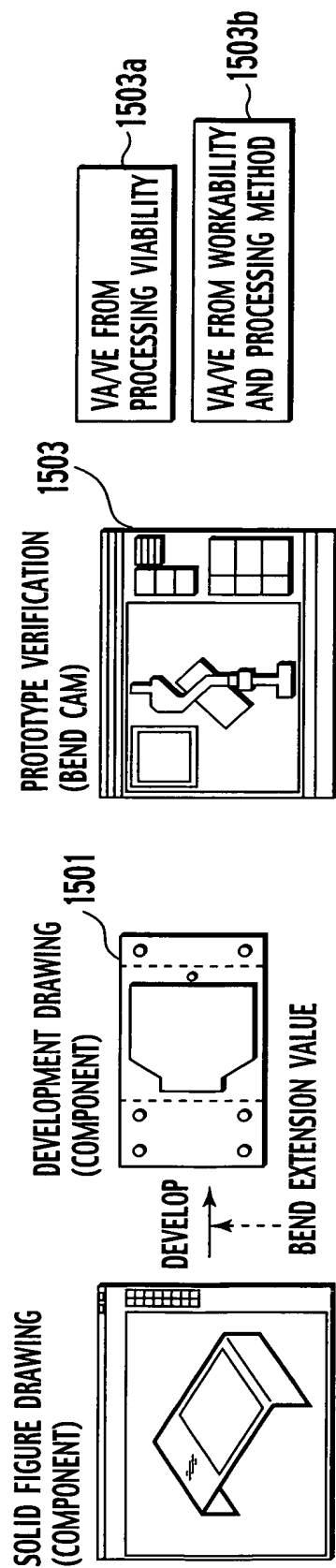


FIG.14



**FIG. 15**



**[BENDING PROCESSING EXPENSES] · · TABLE OF STANDARD UNIT PRICES DIFFERS FOR DIFFERENT MATERIALS/SHEET THICKNESSES**

- **BENDING PROCESSING EXPENSES =  $\Sigma(\text{PROCESSING TIME BY BEND FORM}) \times \text{STANDARD UNIT PRICE FOR BENDING (PER UNIT TIME)}$**

• **BENDING SET UP EXPENSES = NUMBER OF DIES USED × TIME REQUIRED FOR CHANGING DIES ~ 1515b**

**SPECIAL DIE PURCHASING EXPENSES (WHEN SPECIAL DIE REQUIRED)**

$$\frac{1505}{\text{BENDING PROCESSING EXPENSES}} \times \frac{1507}{\text{NUMBER OF SHEETS PROCESSED}} + \frac{1509}{\text{BENDING SET UP EXPENSES}} + \frac{1511}{\text{SPECIAL DIE PURCHASING EXPENSES}}$$

FIG.16

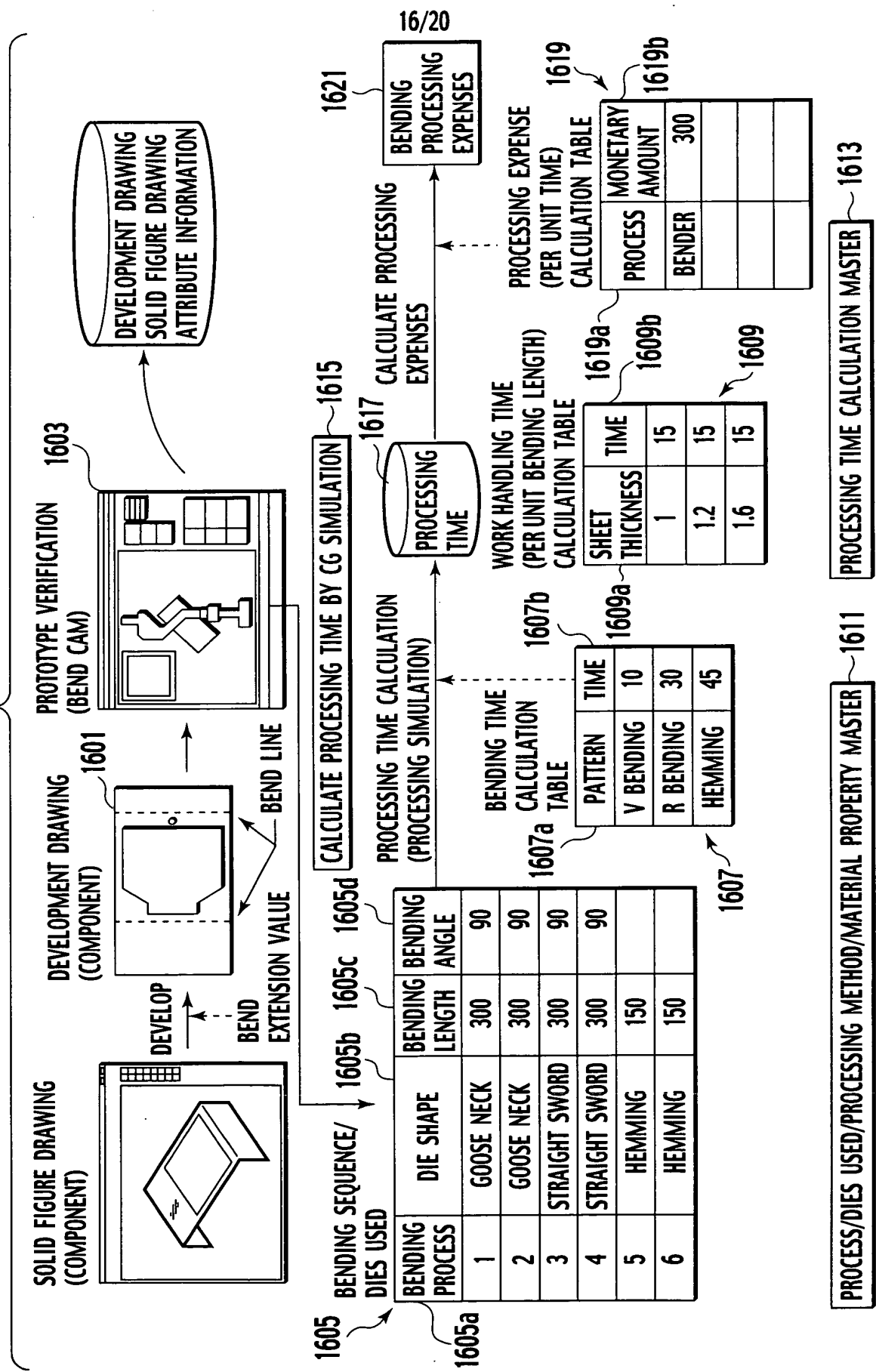




FIG.17

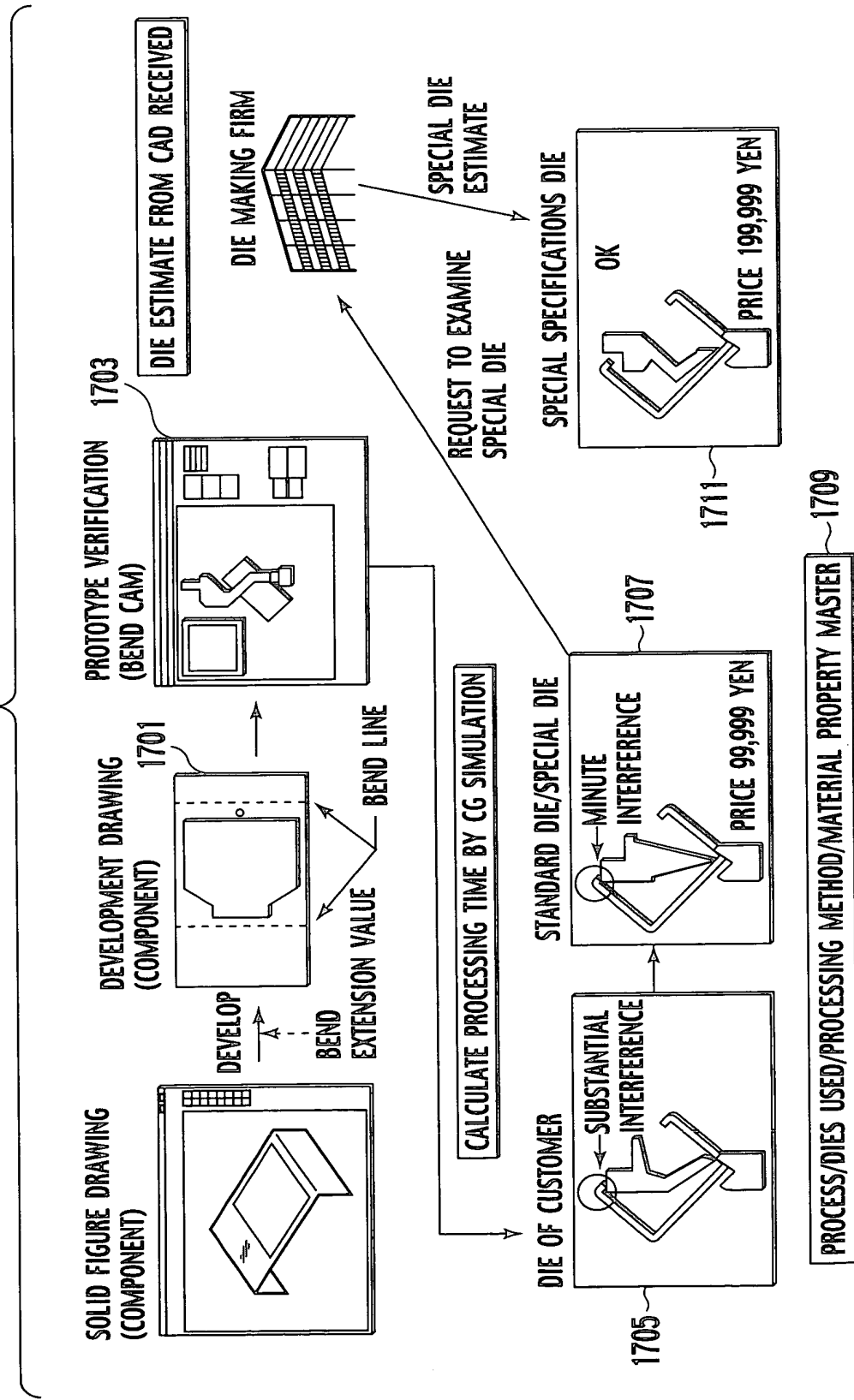


FIG.18

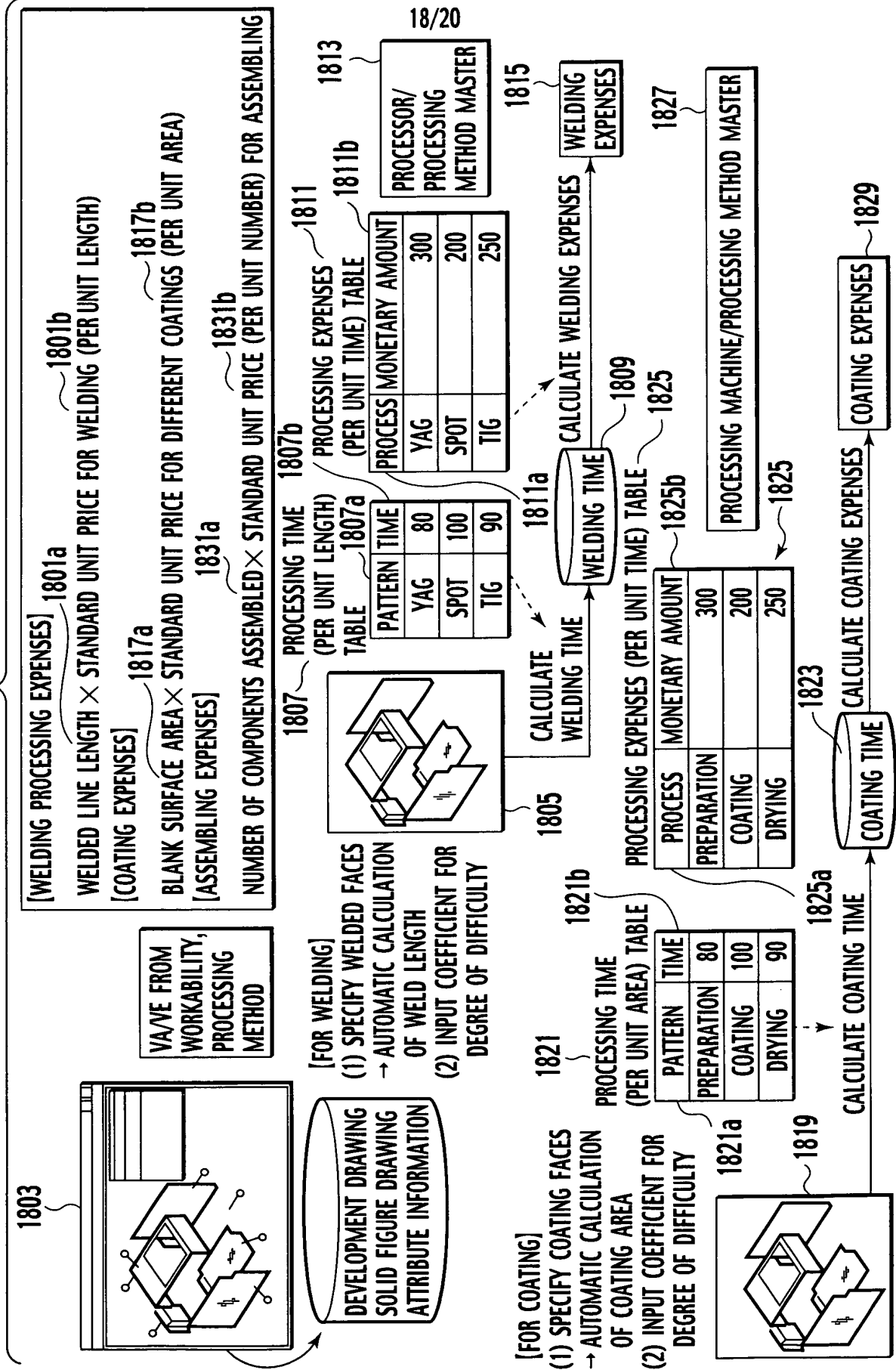


FIG.19

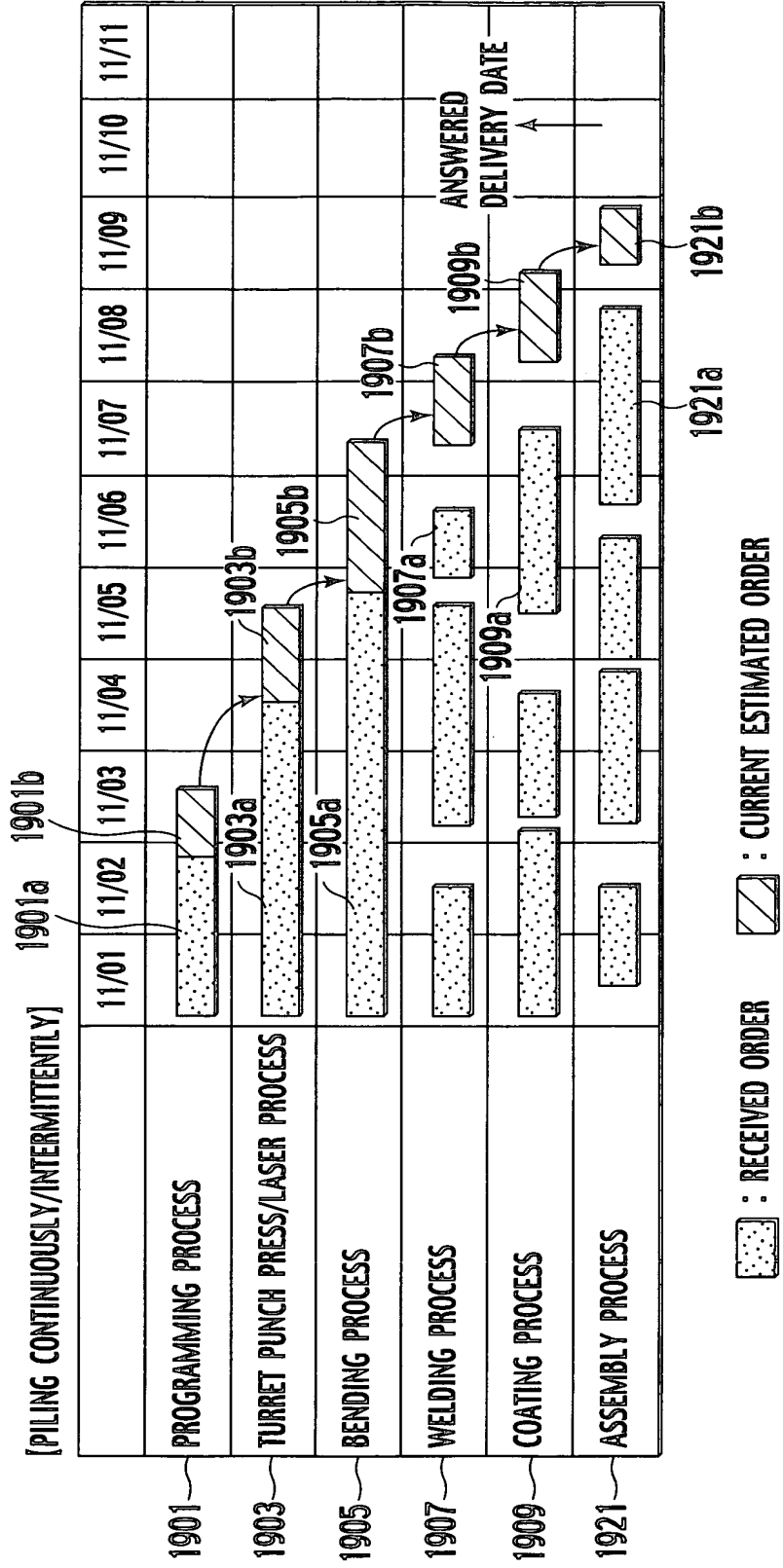


FIG.20

